Dart Aerospace Ltd.

Date: Thursday, 4/12/2007 9:22:46 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET LH/RH 350/355
Job Number	: 31771		
Estimate Number	: 10208		
P.O. Number	: N/A	Part Number	: D350607043
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D350-607 REV F P7-9
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 31504	Material	: N/A
Written By	:	Due Date	: 4/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.04.12		
Comment	: Est Rev:E as Per DSI9318 06-01-24 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPPD350-607-043 CHG003	CL KJ 07.04.17 ①
2.0	31771A	BASKET LID ASSEMBLY
	Comment: Sub-Component BASKET LID ASSEMBLY D2989-041 B 31771A	ml 07/05/08
3.0	31771B	BASKET LID ASSEMBLY
	Comment: Sub-Component BASKET LID ASSEMBLY D2989-043 B 31771B	ml 07/05/08
4.0	31771C	BASKET BASE ASSEMBLY (350)
	Comment: Sub-Component BASKET BASE ASSEMBLY (350) D2221 B 31771C	ml 07/05/08
5.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick: Assemby Kit	
6.0	NAS1515H4	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 NAS1515H4 WASHER M100428	7/5/8 SO

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31771 **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
7.0	D2022101	Spacer

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
5 D2022-101 Spacer B26664

Seq. #:	Machine Or Operation:	Description :
8.0	D2258200	Weight Placard 200lb

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2258-200 Label B28312

Seq. #:	Machine Or Operation:	Description :
9.0	D2332041	Lid Prop Assembly 6.69"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2332-041 Prop Ass'y B30547

Seq. #:	Machine Or Operation:	Description :
10.0	D2530	Handle Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2530 Handle Weldment B30383

Seq. #:	Machine Or Operation:	Description :
11.0	D2535	Spring

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2535 Spring B29363

Seq. #:	Machine Or Operation:	Description :
12.0	D2537	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2537 Bushing B31107

7/5/859

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:22:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31771 **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	D27283	Dart Logo label large

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2728-3	Label	B22558

Seq. #:	Machine Or Operation:	Description :
14.0	D2931	Bumper

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2931	Bumper	B21139

Seq. #:	Machine Or Operation:	Description :
15.0	AN316A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN3-16A	Bolt	M101884

Seq. #:	Machine Or Operation:	Description :
16.0	AN413A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN4-13A	Bolt	M103924

Seq. #:	Machine Or Operation:	Description :
17.0	AN422A	Bolt

Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
7	AN4-22A	Bolt	M100771

Seq. #:	Machine Or Operation:	Description :
18.0	AN517A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	AN5-17A	Bolt	M102140

7/5/8 S9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:22:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31771 **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	AN960JD8	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD8 Washer M103585

20.0	AN960JD416	Washer

Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s) (2) 12
Pick: Assemby Kit
Qty Part Number Description Batch
14 AN960JD416 Washer M102929 M103338

21.0	AN960JD416L	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD416L Washer M103982

22.0	AN960JD516	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M11989

23.0	AN9704	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN970-4 Washer M103344

24.0	MS20600AD4W3	Cherry Rivets

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS20600AD4W3 Rivet M10579

7/5/859

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:22:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31771 **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	MS21042L3	Nut (or -3)	M104215

Seq. #:	Machine Or Operation:	Description :
26.0	MS21042L4	Nut

Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
9	MS21042L4	Nut (or -4)	M103914

Seq. #:	Machine Or Operation:	Description :
27.0	MS21042L5	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	MS21042L5	Nut (or -5)	M102536

7/5/8 SO

Seq. #:	Machine Or Operation:	Description :
28.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291
Batch: M103497
Exp Date: 10/2007

ML 07/05/08 x1

Seq. #:	Machine Or Operation:	Description :
29.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP SB 07/05/09 (1)

Seq. #:	Machine Or Operation:	Description :
30.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Packing Kit

 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:22:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31771 **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	D22301	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2230-1 Lug B30992 -

Seq. #:	Machine Or Operation:	Description :
32.0	D22303	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2230-3 Clamp B29806 -

Seq. #:	Machine Or Operation:	Description :
33.0	D23241	Strut Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 *D2324-1 Strut Ass'y B32065 -

Seq. #:	Machine Or Operation:	Description :
34.0	D2856400	Abrasion Strip

Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2856-400-720 Abrasion Strip B29280 (1X) B30822 (3X)

Seq. #:	Machine Or Operation:	Description :
35.0	AN412A	Bolt

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
5 AN4-12A Bolt ~~M102858~~ M103947 -

Seq. #:	Machine Or Operation:	Description :
36.0	AN413A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 AN4-13A Bolt M104156 -

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/05/10

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:22:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 31771
Part Number: D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
37.0	AN960JD416	Washer

Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
26 AN960JD416 Washer M102828 -

Seq. #:	Machine Or Operation:	Description :
38.0	MS21042L4	Nut

Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
13 MS21042L4 Nut (or -4) M103914 -

Seq. #:	Machine Or Operation:	Description :
39.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS 07/15/09 C2 07/05/09 ①

Seq. #:	Machine Or Operation:	Description :
40.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-607-043
Location:__________ REV: E 07/15/09

Seq. #:	Machine Or Operation:	Description :
41.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 07/05/10

Job Completion 07-05-10

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

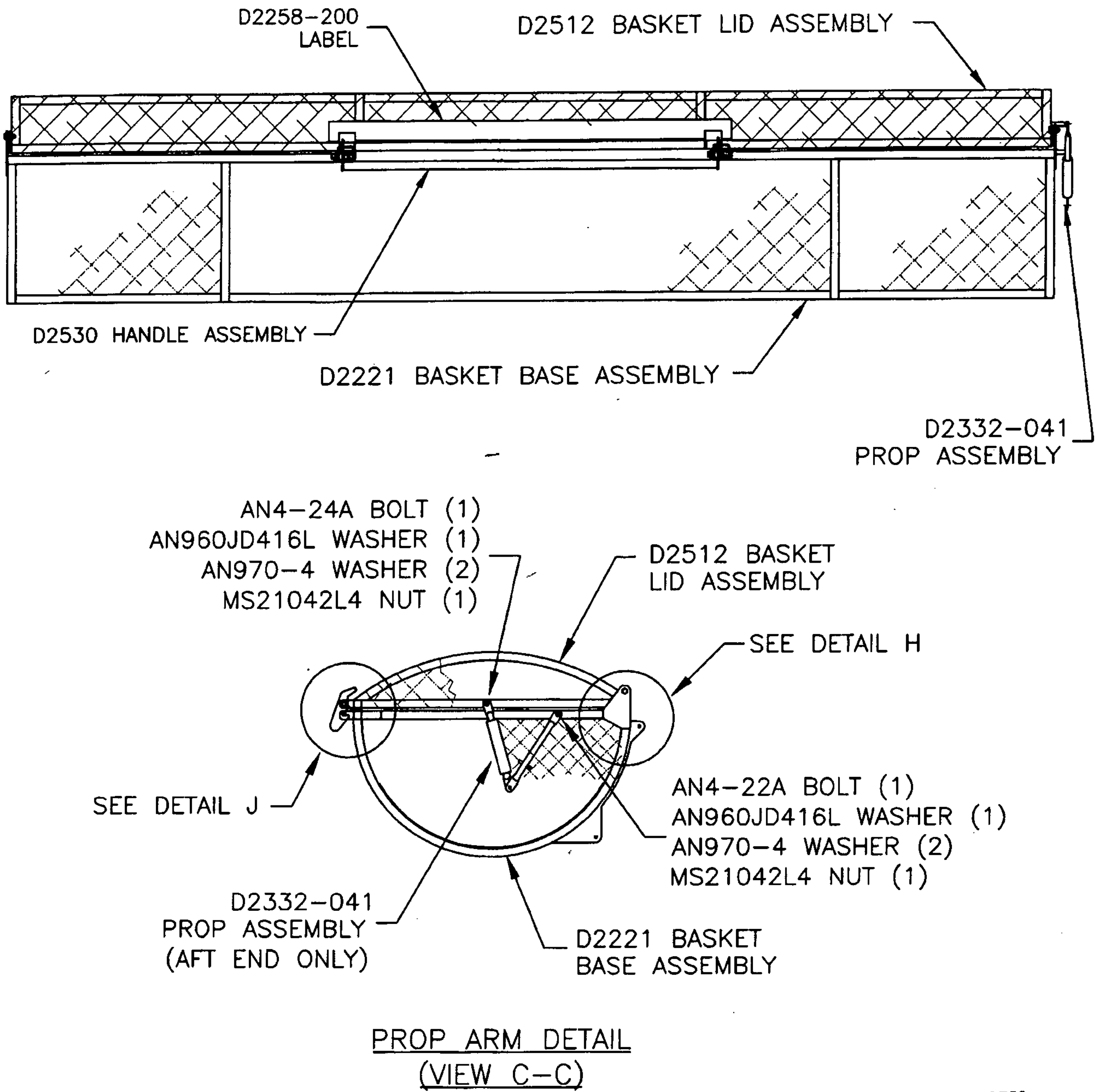
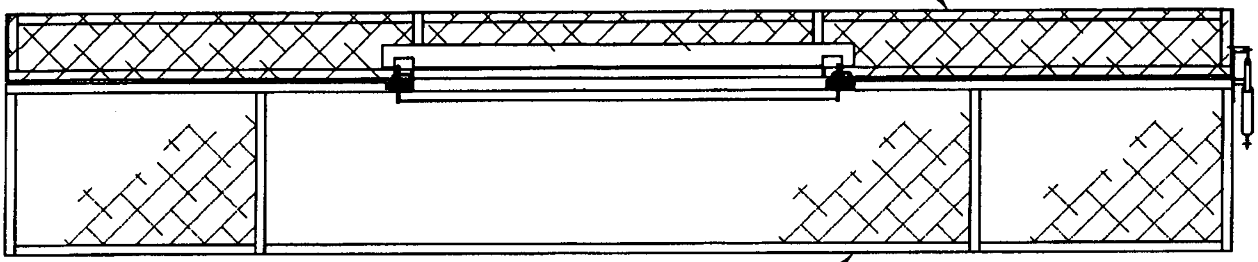
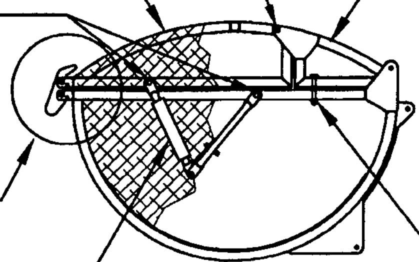


Figure 4 – Basket Replacement Parts

(D350-607-041 Heli-Utility-Basket™)





PROP ARM DETAIL
VIEW C-C

Figure 5– Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)

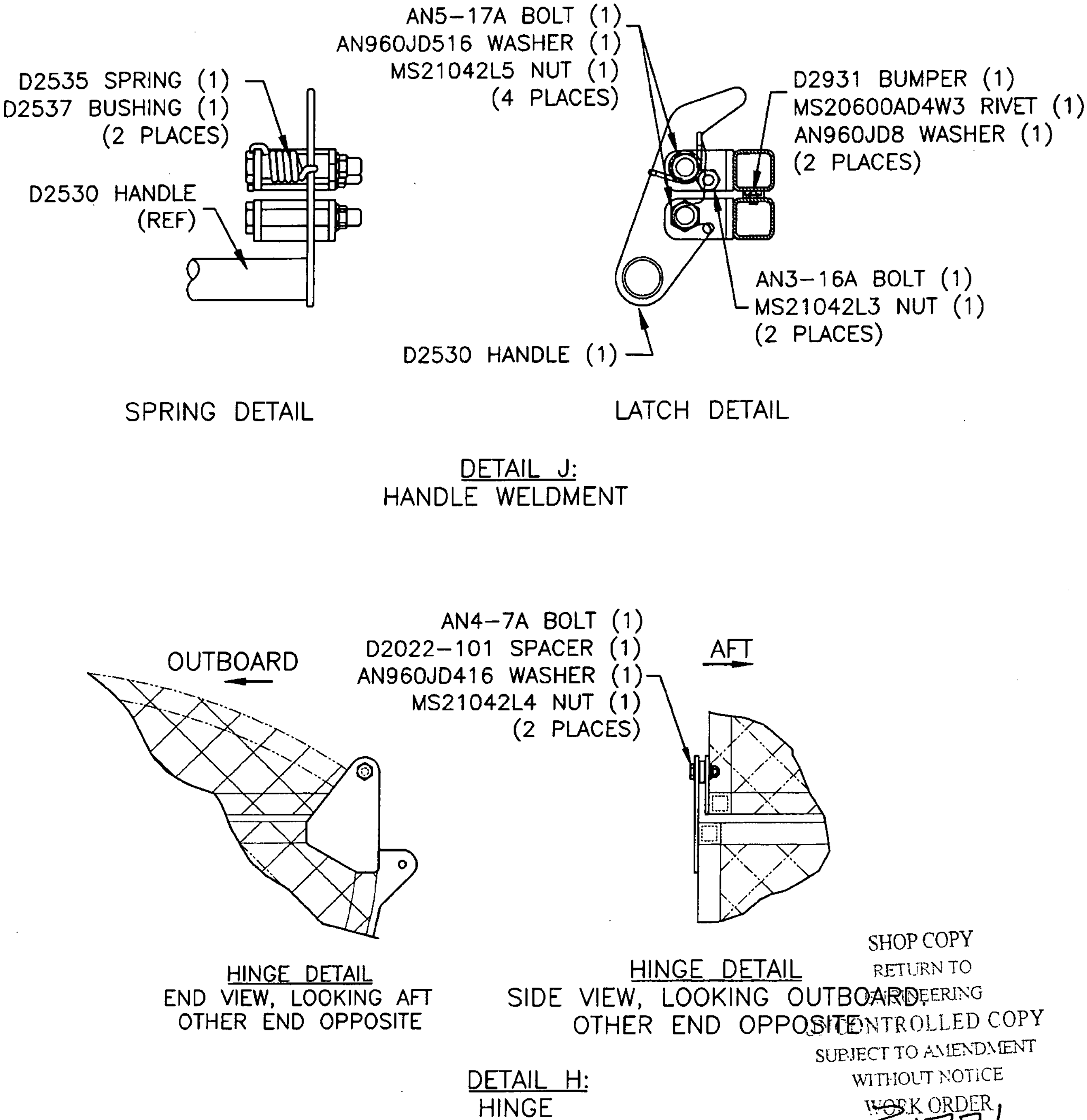


Figure 6 – Basket Replacement Parts

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. DSI 9318 — REV. A — SHEET 1 OF 1
DATE 06.01.06		TITLE WASHER ADDITION — SCALE NTS
A	06.01.06	NEW ISSUE

DART

DART SERVICE INSTRUCTION

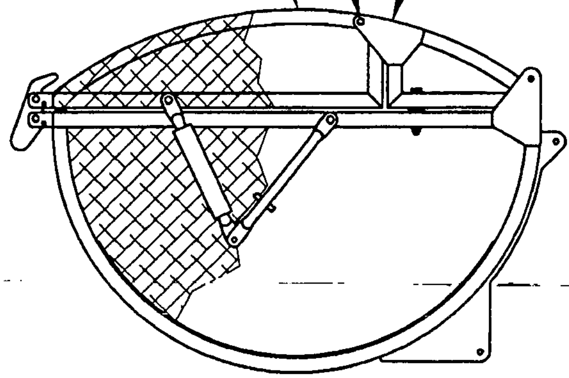
TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

REF. FAA STC: SR00213NY

To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047** *Heli-Utility-Basket*.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3177

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 06.01.06
CERT. NO.: SH94-14
ISSUE NO.: 4

Dart Aerospace Ltd.

Date: Thursday, 4/12/2007 9:23:28 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BASKET BASE ASSEMBLY (350)
Job Number	: 31771C		
Estimate Number	: 10189		
P.O. Number	: N/A	**Part Number**	: D2221
This Issue	: 4/12/2007 **S.O. No.** : N/A	**Drawing Number**	: D2221/D2235
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: F/B1
Previous Run	: 31676A	**Material**	: N/A
Written By	:	**Due Date**	: 4/30/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.04.12		
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	B31425

07/05/04

Seq. #:	Machine Or Operation:	Description :
2.0	D22323	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	B30873

07/05/04

Seq. #:	Machine Or Operation:	Description :
3.0	D2325	Support Gusset (350 Bask

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	B30546

07/05/04

Seq. #:	Machine Or Operation:	Description :
4.0	D23273	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	B28597

07/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:23:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET BASE ASSEMBLY (350)

Job Number: 31771C **Part Number:** D2221

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

5.0 D2581 Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2581 Mounting Bracket B30552

07/05/04

6.0 D34421 Shim

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D3442-1 Shim B30564

07/05/04

7.0 M304EX07516F Expanded Metal Flat Stai

Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)
Pick:
Qty Part Number Description Batch
39.69 sf M304EX0.75-16F Expanded Metal M103840

07/05/04

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W

Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)
Pick:
28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing
Batch: ~~103~~ 104087

07/05/04

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

07/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes ~~No~~ (circled: No) **DQA:** [initials] **Date:** 07/05/10

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:23:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET BASE ASSEMBLY (350)

Job Number: 31771C **Part Number:** D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	PD 07.05.07 (1)
11.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	PD 07.05.07 (1)
12.0	POWDER COATING	POWDER COATING
	N110370G	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	07.08.04 (1)
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	ML 07/05/08
14.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(1) 07/05/10

Job Completion

07.05.10

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

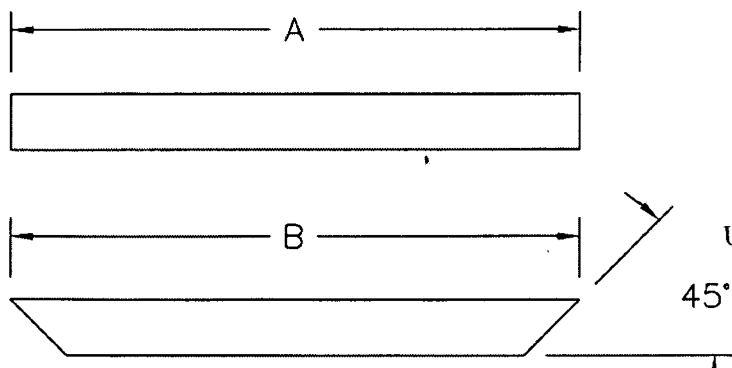
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	PH	
CHECKED	APPROVED	DRAWING NO. D2221 — REV. F — SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350) — SCALE NTS

REV	DATE	DESCRIPTION
C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

RELEASED 05.08.19

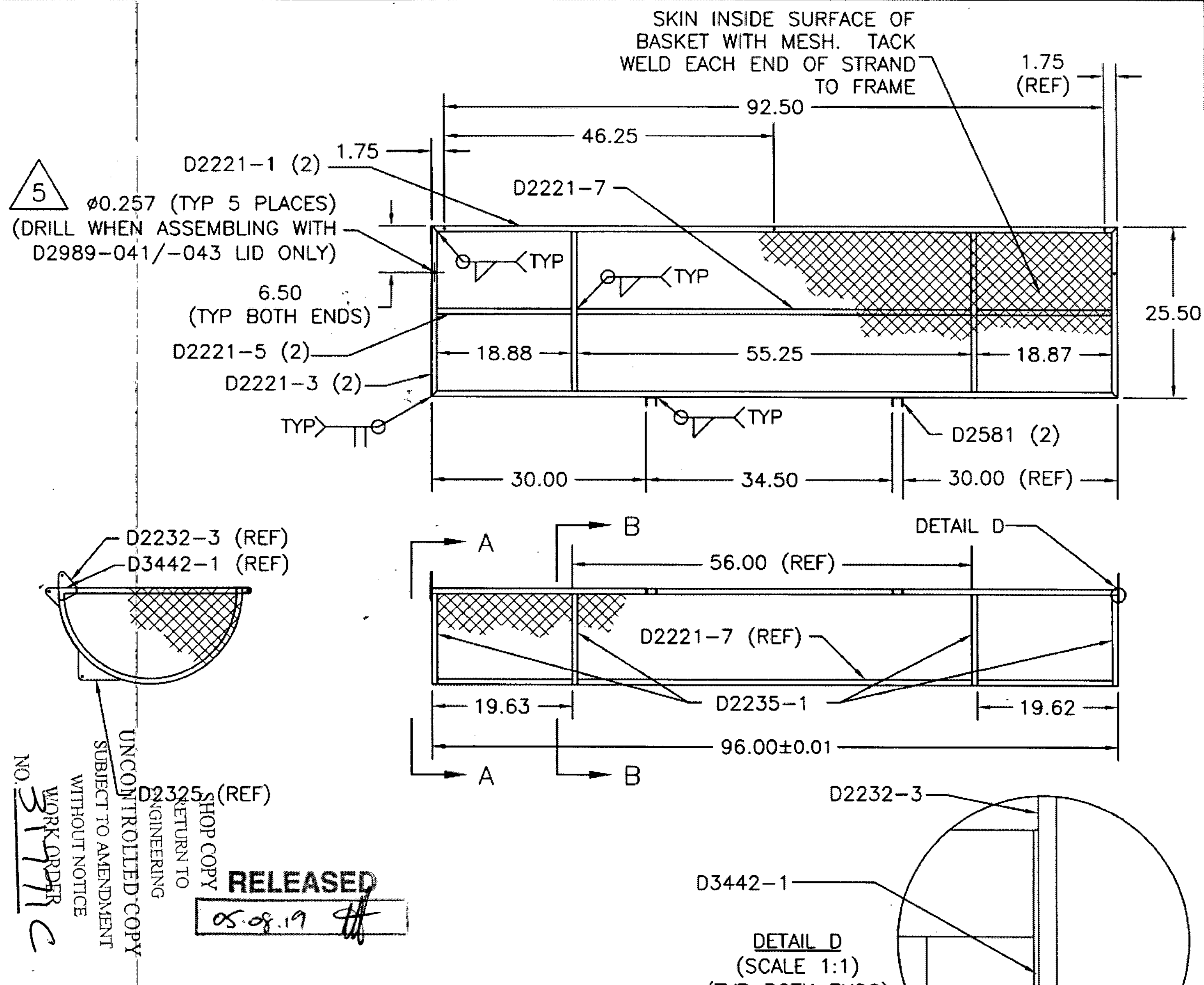
PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	———	96.00	RIB
D2221-3	2	———	25.50	RIB
D2221-5	2	18.88	———	RIB
D2221-7	1	55.25	———	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID



D2221 BASKET BASE ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
2) WELD PER DART QSI 004
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

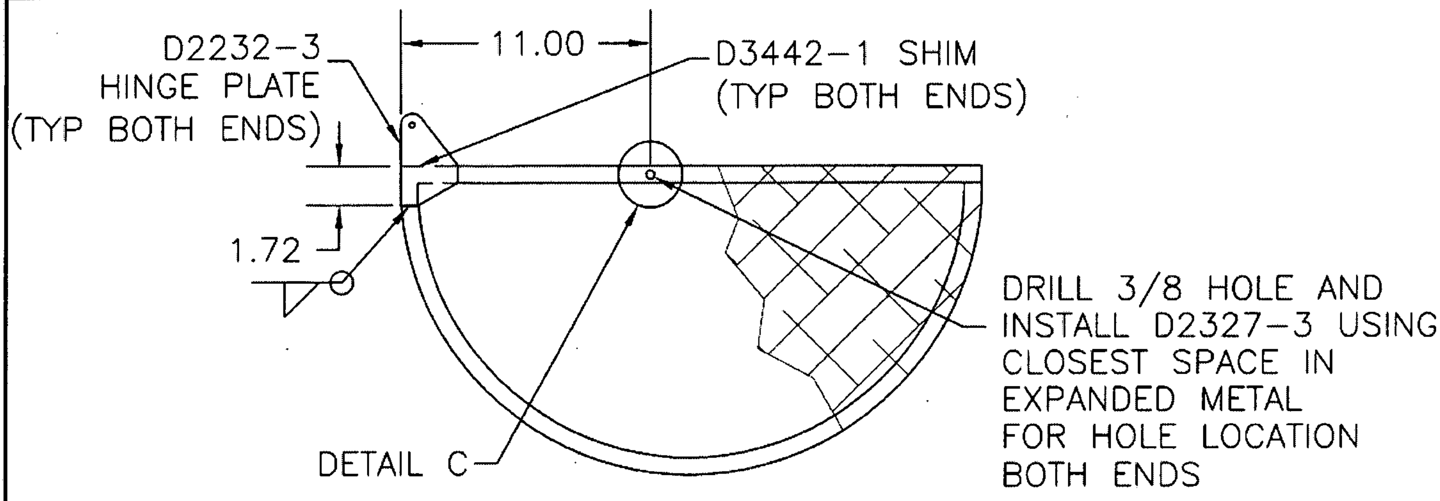
DART

DESIGN	DRAWN BY		
BW	PH		
CHECKED	APPROVED	DRAWING NO. D2221	REV. F
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SHEET 2 OF 3
			SCALE 1:20

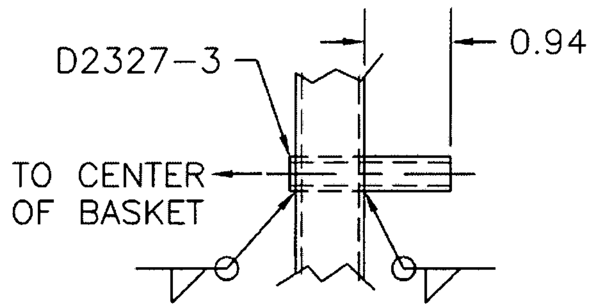
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DART

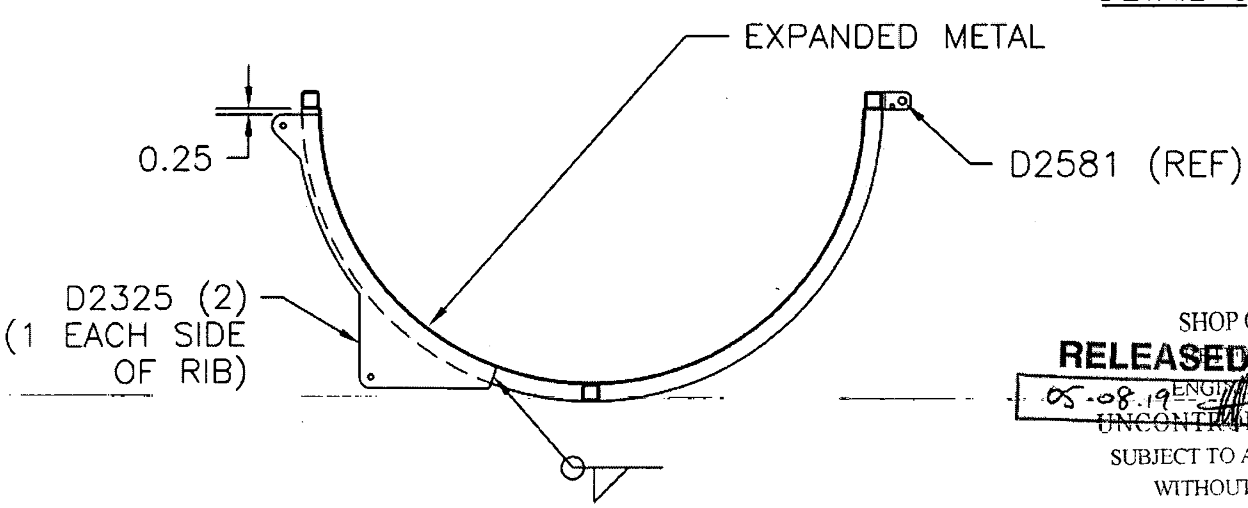
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BW	PH	
CHECKED	APPROVED	DRAWING NO. D2221 — REV. F — SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350) — SCALE 1:8



SECTION A-A SAME BOTH END RIBS

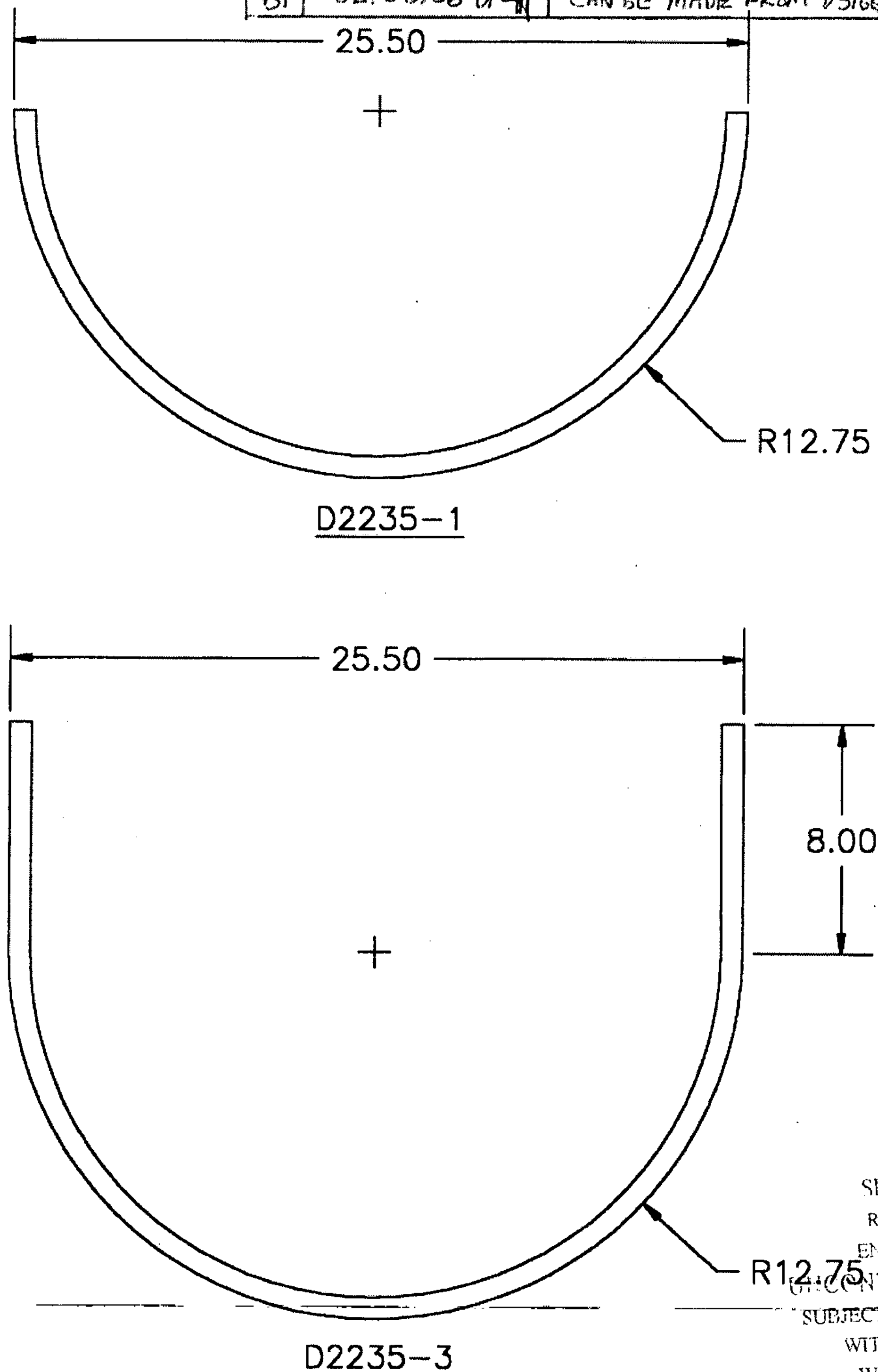


DETAIL C



SECTION B-B SAME BOTH CENTER RIBS

DESIGN	DRAWN BY	DART-AEROSPACE-LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS		
CHECKED	APPROVED	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE
B1	02.08.06	CAN BE MADE FROM D3166-1	



CAN BE MADE FROM D3166-1 (B1)

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

Dart Aerospace Ltd.

Date: Thursday, 4/12/2007 9:23:07 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 31771B		
Estimate Number	: 10207		
P.O. Number	: N/A	Part Number	: D2989043
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 31504B	Material	: N/A
Written By	:	Due Date	: 4/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.04.12		
Comment	: Est Rev:I Removed D2989-041 05-11-03 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31821	Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part number Description Batch
2 D3182-1 Hinge B31342

07/05/04

Seq. #:	Machine Or Operation:	Description :
2.0	D34423	Shim

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part number Description Batch
2 D3442-3 Shim B26740

07/05/04

Seq. #:	Machine Or Operation:	Description :
3.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)
Pick:
Qty Part number Description Batch
8sf M304EX0.75-16F Expanded Metal BM103840

07/05/04

Seq. #:	Machine Or Operation:	Description :
4.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)
3/4" x 3/4" x 0.063" wall 304/316 SStubing.
Batch: 104087

07/05/04

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/03/10

QA: N/C Closed: ______ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Thursday, 4/12/2007 9:23:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET LID ASSEMBLY

Job Number: 31771B **Part Number:** D2989043

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989
Note:D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

07/05/04

Seq. #:	Machine Or Operation:	Description :
6.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION   07-05-07 (1)

Seq. #:	Machine Or Operation:	Description :
7.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK   07-05-07 (1)

Seq. #:	Machine Or Operation:	Description :
8.0	POWDER COATING	POWDER COATING

M\ 103706

Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989   07-05-07 (1)

Seq. #:	Machine Or Operation:	Description :
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: Inspect Powder Coat   ml 07/05/08

Seq. #:	Machine Or Operation:	Description :
10.0	QC21	FINAL INSPECTION/W/O RELEASE

(1)

Comment: FINAL INSPECTION/W/O RELEASE   07/05/10

Job Completion

07.05.10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D2989 REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY SCALE NTS

REV	DATE	DESCRIPTION
A	00.10.27	NEW ISSUE
B	05.06.07	ADD SHIM UNDER HINGES,UPDATE LID DIMENSIONS

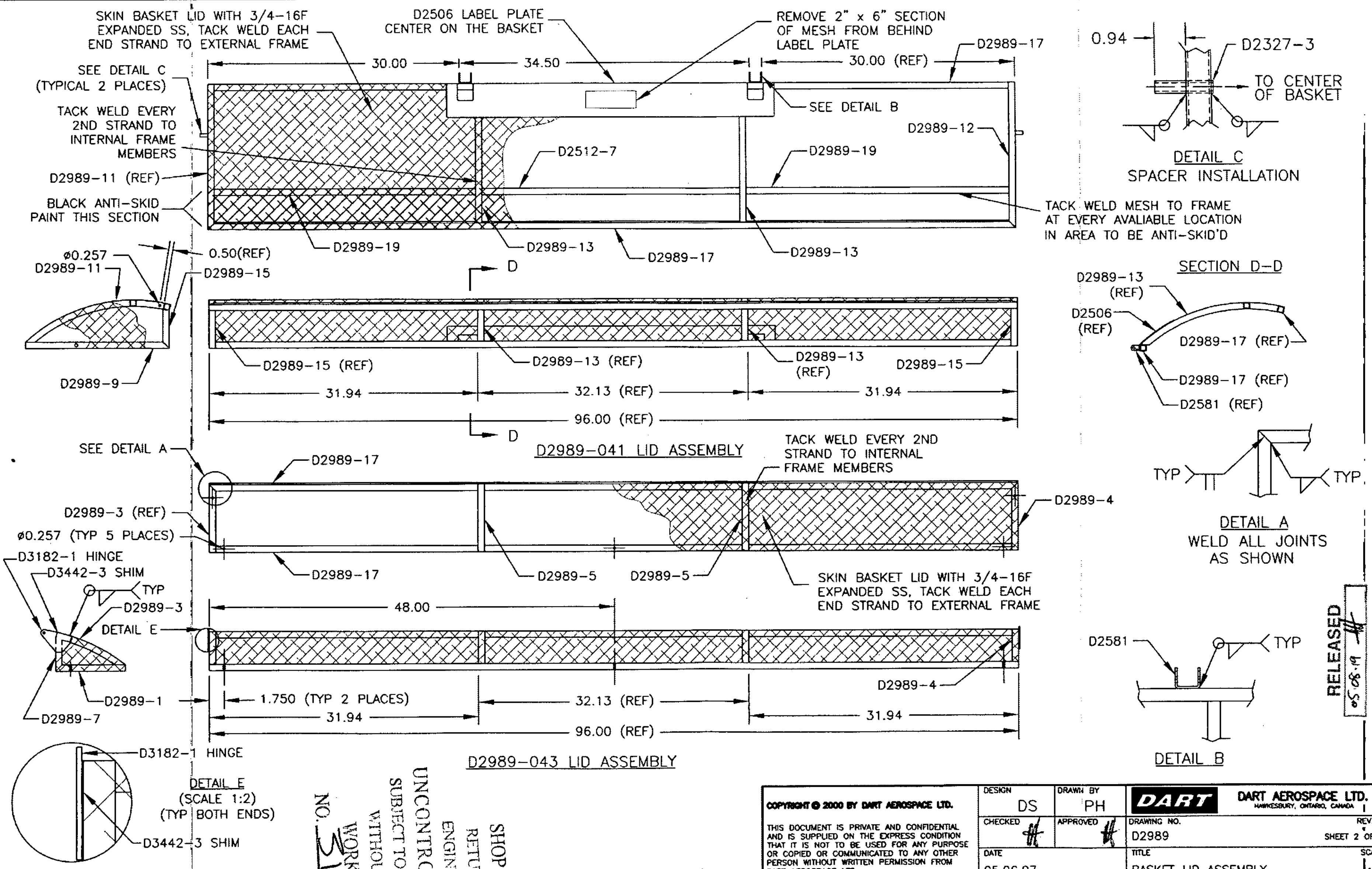
RELEASED
05.08.19

PARTS LIST:

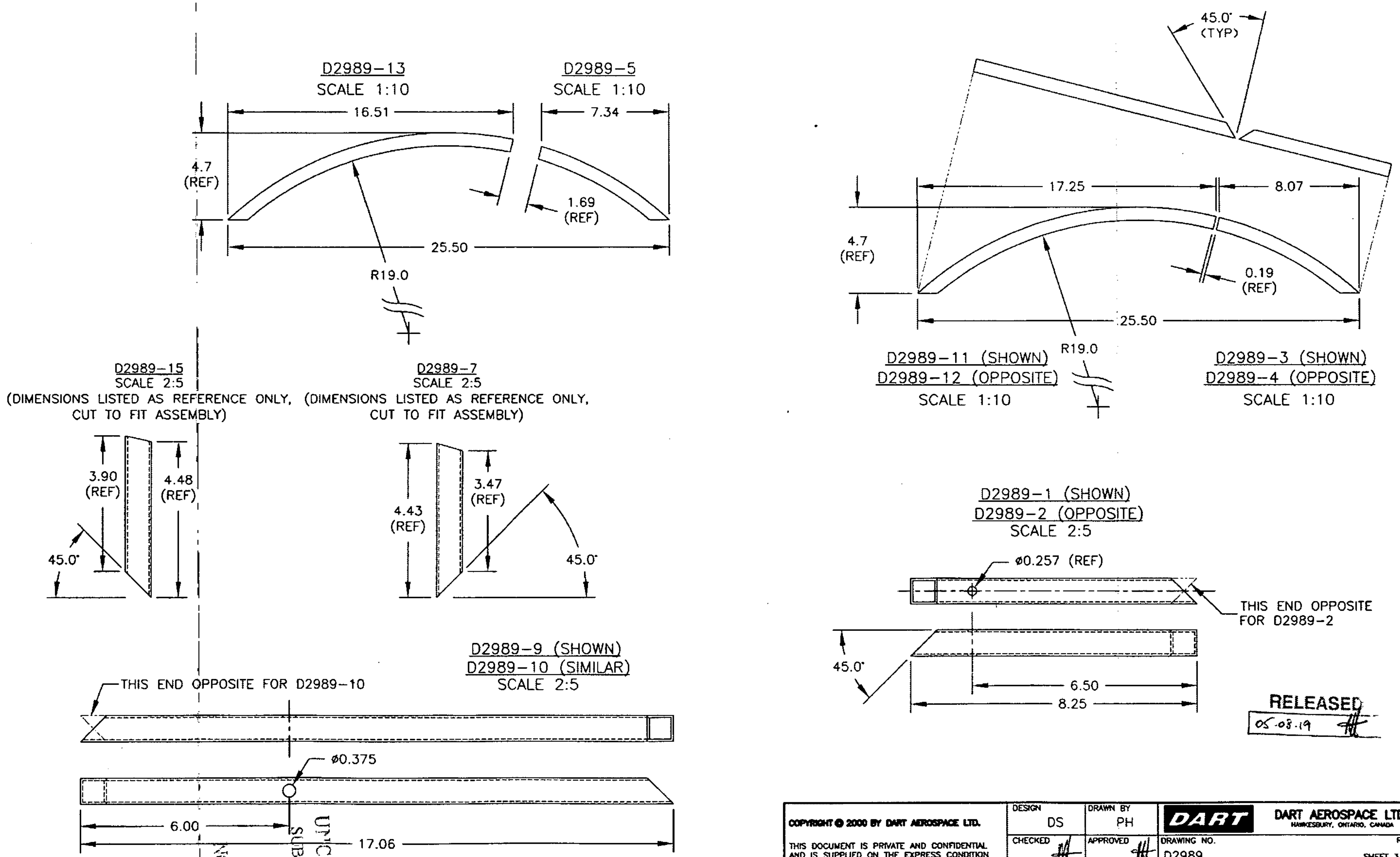
Qty -041	Qty -043	Part Number	Description
X		**D2989-041**	**BASKET LID ASSEMBLY (OUTSIDE)**
	X	**D2989-043**	**BASKET LID ASSEMBLY (INSIDE)**
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

NOTES:

1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART-QSI-005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
5) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D2989 — REV. B — SHEET 2 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY — SCALE 1:10



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	DATE: 05.06.07		TITLE: BASKET LID ASSEMBLY	SCALE 1:10

Date: Thursday, 4/12/2007 9:22:59 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 31771A		
Estimate Number	: 10206		
P.O. Number	: N/A	Part Number	: D2989041
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 31504A	Material	: N/A
Written By	:	Due Date	: 4/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.04.12		
Comment	: Est Rev:I Removed D2989-043 05-11-03	JLM	

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31663	Basket Hoop

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty.(1) D3166-3 Batch: B31118 — 07/05/04

2.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
2	D2581	Mounting Brackets	B20873

07/05/04

3.0	D23273	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
2	D2327-3	Bushing	B28797

07/05/04

4.0	D2506	Placard

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
1	D2506	Label Plate	B30548

07/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:22:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET LID ASSEMBLY

Job Number: 31771A **Part Number:** D2989041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)
Pick:
Qty Part number Description Batch
15sf M304EX0.75-16F Expanded Metal M103840 07/05/07

6.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)
3/4" x 3/4" x 0.063" wall 304/316 SStubing.
Batch: 104087 07/05/07

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989Identify as D2989-041

07/05/04

8.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07.05.07

9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07.05.07

10.0	POWDER COATING	POWDER COATING

M103706

Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

07.05.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes (No) **DQA:** [illegible] **Date:** 07/05/10

QA: N/C Closed: _____ **Date:** __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:22:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 31771A

Part Number: D2989041

Job Number:

Seq. #:	Machine Or Operation:	Description :
	2-Wing walk D2989-041, as per Dwg D2989 and QSI 005 4.4 Spray Paint Black: M103703 Wing Walk: M103707	M-h 07/05/08 (1)
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: Inspect Powder Coat and Wing Walk	ml 07/05/08
12.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(1) 07/05/10

Job Completion

4/ A-05-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2989 REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY SCALE NTS

DART

A		00.10.27	NEW ISSUE
B		05.06.07	ADD SHIM UNDER HINGES,UPDATE LID DIMENSIONS

RELEASED 05.08.19

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		**D2989-041**	**BASKET LID ASSEMBLY (OUTSIDE)**
	X	**D2989-043**	**BASKET LID ASSEMBLY (INSIDE)**
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

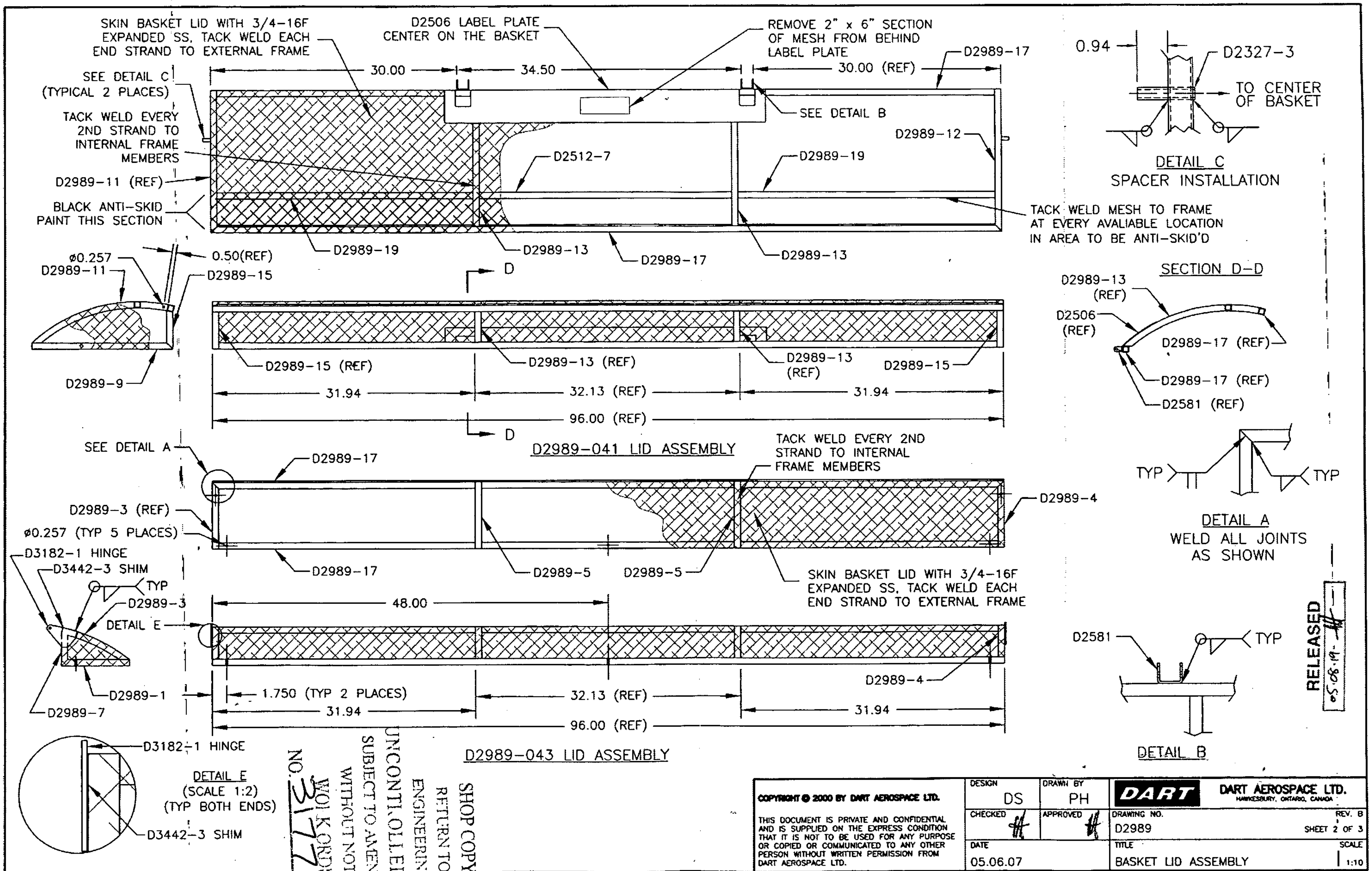
SHOP COPY RETURN TO ENGINEERING

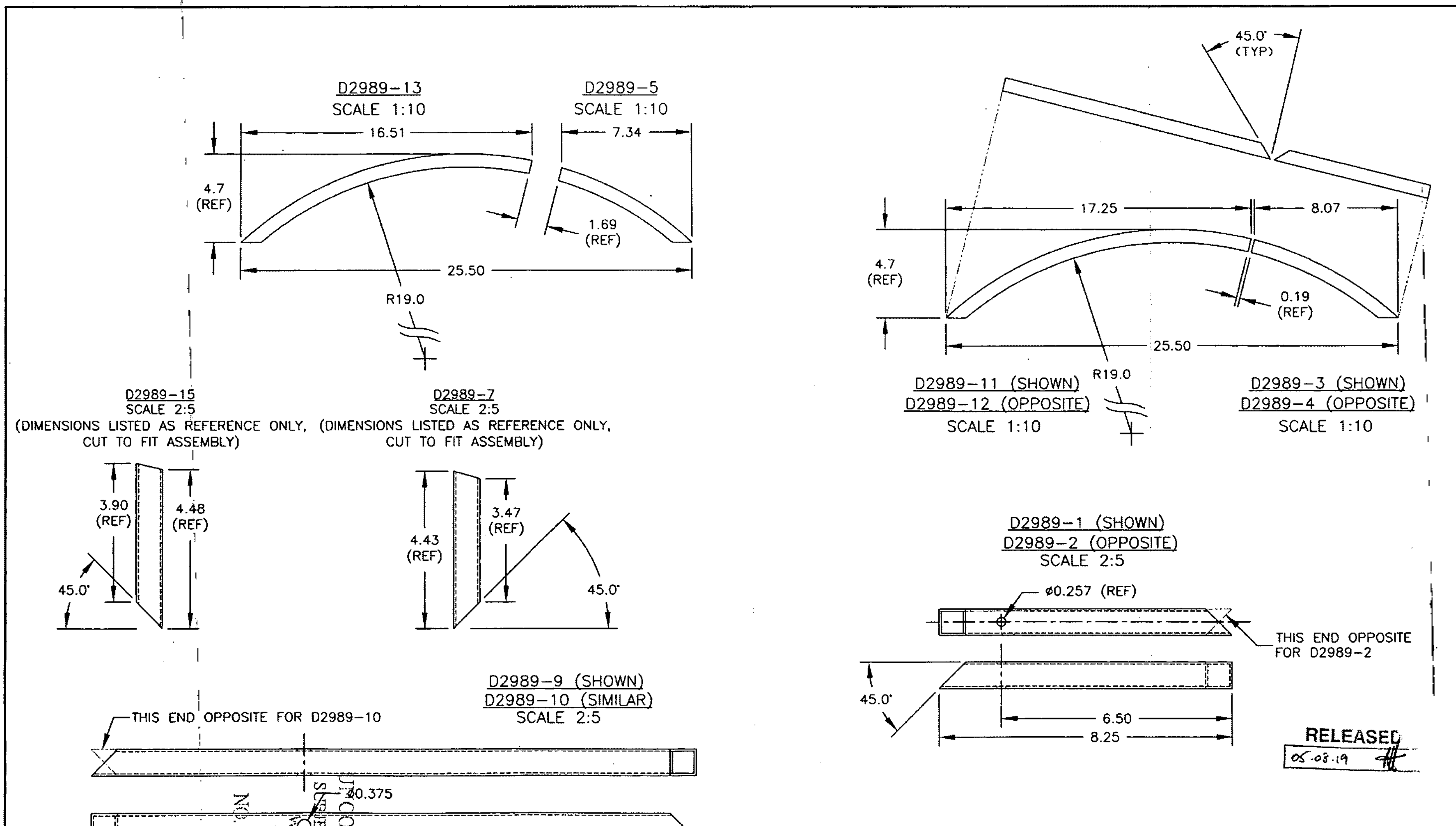
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 31771A

NOTES:

1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
   D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
   BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
5) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME
D2506 LABEL PLATE CENTER ON THE BASKET
REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE
D2989-17
30.00
34.50
30.00 (REF)
SEE DETAIL C (TYPICAL 2 PLACES)
SEE DETAIL B
D2989-12
TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS
D2512-7
D2989-19
D2989-11 (REF)
BLACK ANTI-SKID PAINT THIS SECTION
TACK WELD MESH TO FRAME AT EVERY AVALIABLE LOCATION IN AREA TO BE ANTI-SKID'D
D2989-19
D2989-13
D2989-17
D2989-13
0.94
D2327-3
TO CENTER OF BASKET
DETAIL C
SPACER INSTALLATION
ø0.257
D2989-11
0.50(REF)
D2989-15
D
D2989-9
D2989-15 (REF)
D2989-13 (REF)
D2989-13 (REF)
D2989-15
31.94
32.13 (REF)
31.94
96.00 (REF)
D
D2989-041 LID ASSEMBLY
SECTION D-D
D2989-13 (REF)
D2506 (REF)
D2989-17 (REF)
D2989-17 (REF)
D2581 (REF)
SEE DETAIL A
D2989-17
TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS
D2989-4
D2989-3 (REF)
ø0.257 (TYP 5 PLACES)
D2989-17
D2989-5
D2989-5
SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME
TYP
TYP
DETAIL A
WELD ALL JOINTS AS SHOWN
D3182-1 HINGE
D3442-3 SHIM
TYP
D2989-3
DETAIL E
48.00
D2989-1
D2989-7
1.750 (TYP 2 PLACES)
31.94
32.13 (REF)
31.94
96.00 (REF)
D2989-4
D2581
TYP
DETAIL B
RELEASED 05.08.19
D3182-1 HINGE
DETAIL E (SCALE 1:2) (TYP BOTH ENDS)
D3442-3 SHIM
D2989-043 LID ASSEMBLY
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DATE 05.06.07
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HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D2989
REV. B
SHEET 2 OF 3
TITLE BASKET LID ASSEMBLY
SCALE 1:10



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DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE 1:10

